



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Tel (613) 632-5200

D3168-042
Job Sheet 178497



Part No: D3168-042

Job Qty: 1 ea

Part Name: Step Assembly, Low Short RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 16.03.15 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/8/18	0.00	0.00	Start Up Large Fab-4		DE 2018-06-28
110	Large Fab	1 pcs		6/8/18	0.00	1.33	Large Fab 8		DE 2018-06-25
120	QC	1 pcs		6/8/18	0.00	0.00	QC6		CPC
130	Large Fab	1 pcs		6/8/18	0.70	1.33	Large Fab 2		CPC
140	QC	1 pcs		6/8/18	0.00	0.00	QC9		EL
150	QC	1 pcs		6/8/18	0.00	0.00	QC5		EL
160	HandFinish	1 pcs		6/8/18	0.00	0.41	HandFinish1		BEB 18-06-26
170	QC	1 pcs		6/8/18	0.00	0.00	QC7-2		CPC
180	Large Fab	1 pcs		6/8/18	0.00	1.33	Large Fab 2		CPC
190	QC	1 pcs		6/8/18	0.00	0.00	QC5		M 2018-06-26
200	HandFinish	1 pcs		6/8/18	0.00	0.41	HandFinish6		CPC
210	Powdercoat	1 pcs		6/8/18	0.00	0.49	Powdercoat1		DE 18-6-25
220	HandFinish	1 pcs		6/8/18	0.00	0.41	HandFinish3		M 18-6-27
230	QC	1 pcs		6/8/18	0.00	0.00	QC3		38
290	Packaging	1 pcs		6/8/18	0.00	0.00	Packaging3-1		M 18-6-27
300	QC21-SA	1 Ea		6/8/18	0.00	0.00	QC21		DE 21

Part Op 110 - 1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168

Descriptions: 130 - 1-Bevel end for welding FWD ONLY

180 - Rivet Leg Assembly as per Dwg D3168

210 - START TIME: 2:40

CUT: 3:00 FINISH: 3:10.
MBS839

JUN 27 2018
Fg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	.5000 Ea (.5 ea)	90-Start up Operation	5046116
D3067-1	End Plate	1 Ea (1 ea)	90-Start up Operation	5077589
D3067-1	End Plate	1 Ea (1 ea)	180-Large Fab	5077589
D3077-1	Step Leg	2 Ea (2 ea)	180-Large Fab	5081376
D3170-1	Spacer	2 Ea (2 ea)	180-Large Fab	164390
D3219-5	Plate	2 Ea (2 ea)	180-Large Fab	146687
MS20600-AD4W4	Rivet	12 Ea (12 ea)	180-Large Fab	5041171

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

90-Start up Operation	D2622-120C	1	120	0
	D3067-1	1	148	0
180-Large Fab	D3067-1	1	148	0
	D3077-1	2	2	0
	D3170-1	2	11	0
	D3219-5	2	19	0
	MS20600-AD4W4	12	1,417	0

Part Specifications

Specifications could not be found.

Plex 6/1/18 7:30 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Job No 178497

Longfab
opp: 180 hantab

Container No: S083810



Part: D3168-042

Job No: 178497

Serial No/Batch: S083810

Revision:

Inspector:

Exp Date:

Instructions:

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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/25/18

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermofforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date: _____	Step #: _____	QTY Effective: _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Mistread ☐ Turning Sequence ☐			